

Date: Wednesday, 7/11/2007 2:46:52 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 33477	
Estimate Number : 10675	
P.O. Number : N/A	Part Number : D3443041
This Issue : 7/11/2007 S.O. No. : N/A	Drawing Number : D3443 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 29671	Material : N/A
Written By : _____	Due Date : 7/30/2007 Qty: 3 Um: Each
Checked & Approved By : <u>07.07.11</u>	
Comment : EST REV. A 05.11.17 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34431	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-1	lug	B29366

PD 07-07-12 ①

2.0	D34435	Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-5	Tubing	B29840

PD 07-07-12 ①

3.0	D34531	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-1	Clevis	B29677

PD 07-07-12 ①

4.0	238805	SS DOWEL PIN 3/4" LONG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-805	SS DOWEL PIN 3/4" LONG	M19080

PD 07-07-12 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33477

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Weld assembly as per dwg D3443

PD 07-07-12 (3)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MF 07/07/20 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/20 (x3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
1-Mask holes as per dwg D3443

m 105068

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BR 07-07-24 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-07-25 (3)

10.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

63215K32

Spherical Bearing

m102812 x 1 m, m10399 x 2 m

MF 07-07-25

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

MF 07-07-25

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/05 (x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/25

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:46:52 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33477

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A

mf 07-07-25 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3-)  
07/07/25

Job Completion



U 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

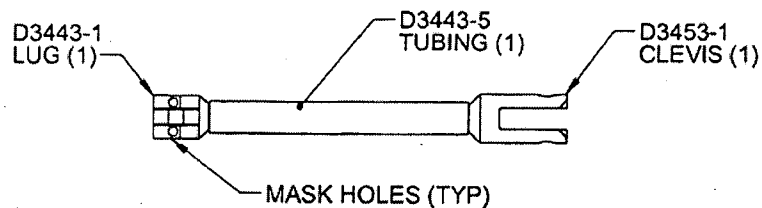
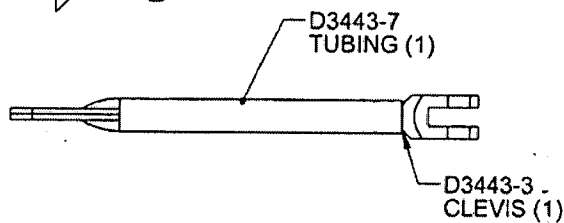
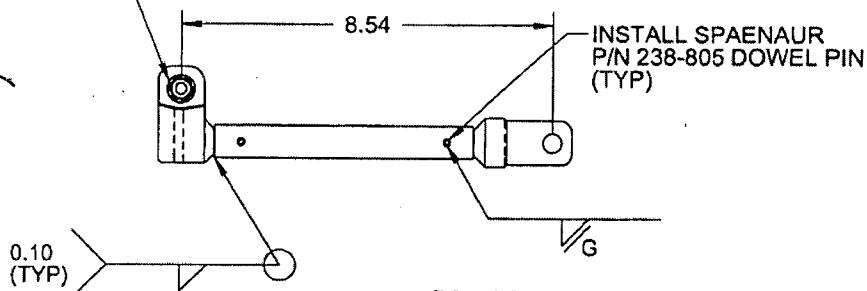
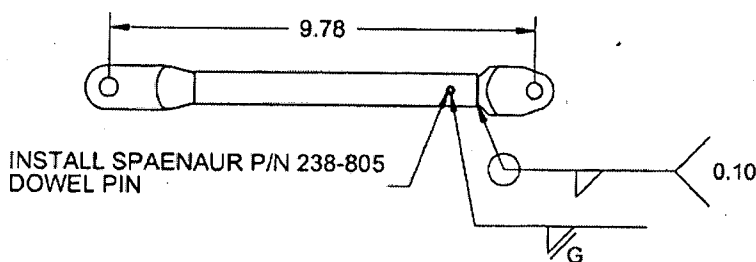
NOTE: Date & initial all entries

**DART**

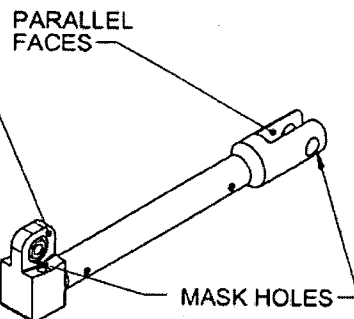
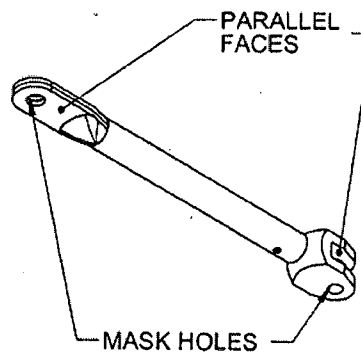
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CHECKED #	APPROVED #	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

**RELEASED**

05.12.09 #

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COATINSTALL SPAENAU P/N 238-805  
DOWEL PIN**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**

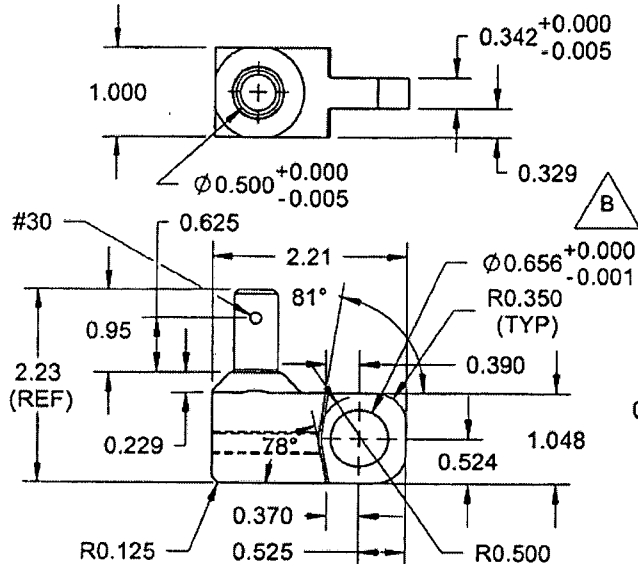
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33477

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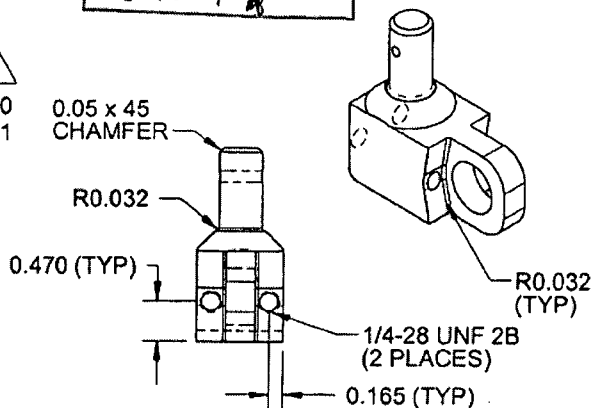
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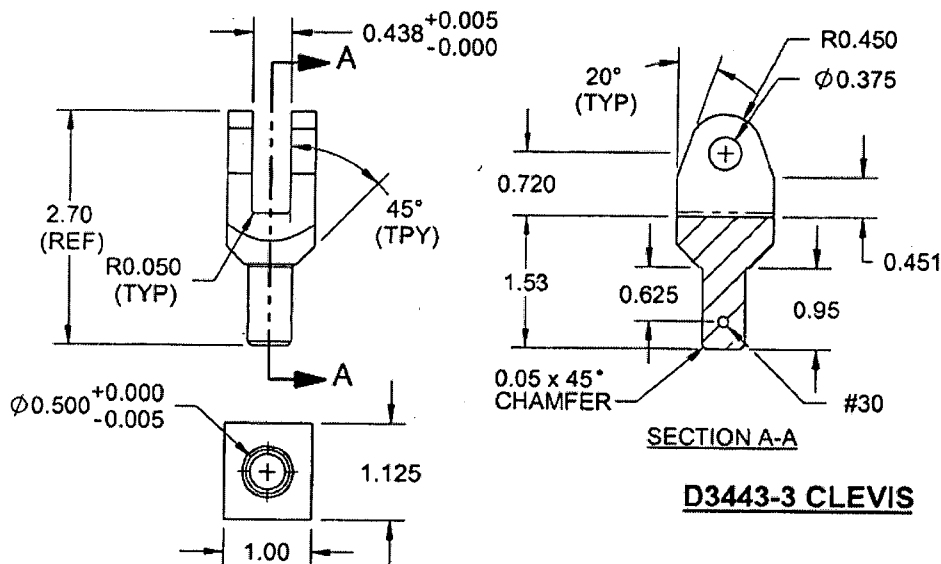
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CHECKED #	APPROVED #	DRAWING NO. <b>D3443</b>	REV. B SHEET 2 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY 1:2</b>		

**RELEASED**

05.12.09 #

**D3443-1 LUG****D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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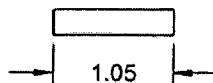
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CHECKED #	APPROVED #	DRAWING NO. <b>D3443</b>	REV. B SHEET 3 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



**D3443-9 PIN**

**D3443-9 NOTES:**

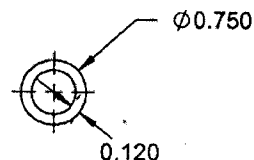
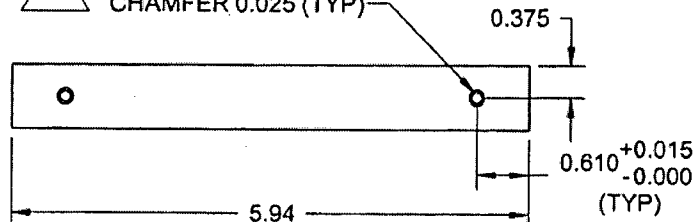
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09

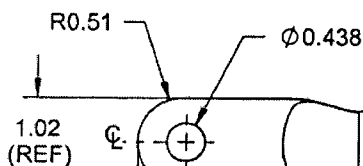
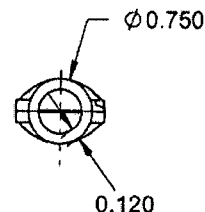
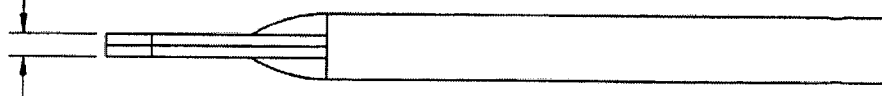


DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)

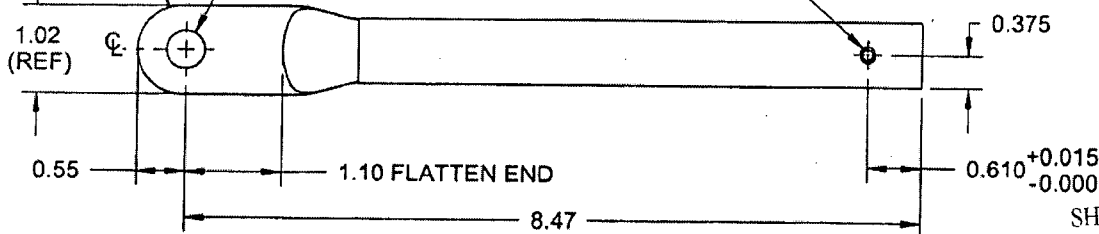


**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025



**D3443-7 TUBING**

**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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